

Date: Thursday, 02/04/2009 2:28:44 PM
 User: Julie Dawson

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : GASKET |
| Job Number : 46883 | |
| Estimate Number : 12722 | |
| P.O. Number : | Part Number : D353615 |
| This Issue : 02/04/2009 S.O. No. : | Drawing Number : D3536 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 40287 | Material : |
| Written By : | Due Date : 10/04/2009 Qty: 12 Um: Each |
| Checked & Approved By : <u>JUD 09.04.03</u> | |
| Comment : Est Rev:A New Issue 07-02-14 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|------------|----------------------|
| 1.0 | MNEO60S063 | NEOPRENE SHEET 0.063 |
|-----|------------|----------------------|



GUT OF MAT



Comment: Qty.: 1.1122 sf(s)/Unit Total : 13.3462 sf(s)

NEOPRENE SHEET 0.063

Batch: 111015 B9-4-14

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: A B9-4-14Prog Rev: A

(6)

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

B9-4-14**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK8 09/04/15

(H6)

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: 111015A09/04/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:28:44 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 46883

Part Number: D353615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/15 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-04-15

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|---------------|------------------------------|
| DART AEROSPACE LTD | | Work Order: 46883 |
| Description: Gasket | | Part Number: D3536-15 |
| Inspection Dwg: D3536 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 39.15 | +/-0.030 | 39.15 | ✓ | | | |
| 35.65 | +/-0.030 | 35.65 | ✓ | | | |
| 33.65 | +/-0.030 | 33.65 | ✓ | | | |
| 30.15 | +/-0.030 | 30.15 | ✓ | | | |
| 24.90 | +/-0.030 | 24.90 | ✓ | | | |
| 19.65 | +/-0.030 | 19.65 | ✓ | | | |
| 14.40 | +/-0.030 | 14.40 | ✓ | | | |
| 9.15 | +/-0.030 | 9.15 | ✓ | | | |
| 5.65 | +/-0.030 | 5.65 | ✓ | | | |
| 3.90 | +/-0.030 | 3.90 | ✓ | | | |
| 8.00 | +/-0.030 | 8.00 | ✓ | | | |
| 16.00 | +/-0.030 | 16.00 | ✓ | | | |
| 24.00 | +/-0.030 | 24.00 | ✓ | | | |
| 0.30 | +/-0.030 | 0.306 | ✓ | | | |
| 0.30 | +/-0.030 | 0.306 | ✓ | | | |
| 1.89 | +/-0.030 | 1.888 | ✓ | | | |
| Ø0.19 | +0.005/-0.001 | 0.190 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|-----------------------|-----------------------|----------------------------|-----|
| Measured by: B | Audited by: S | Prototype Approval: | N/A |
| Date: 9-4-14 | Date: 09/04/15 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.03.14 | New Issue | KJ/JLM | |

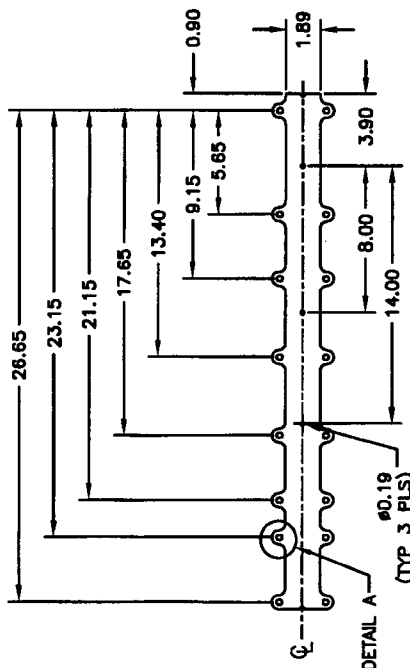
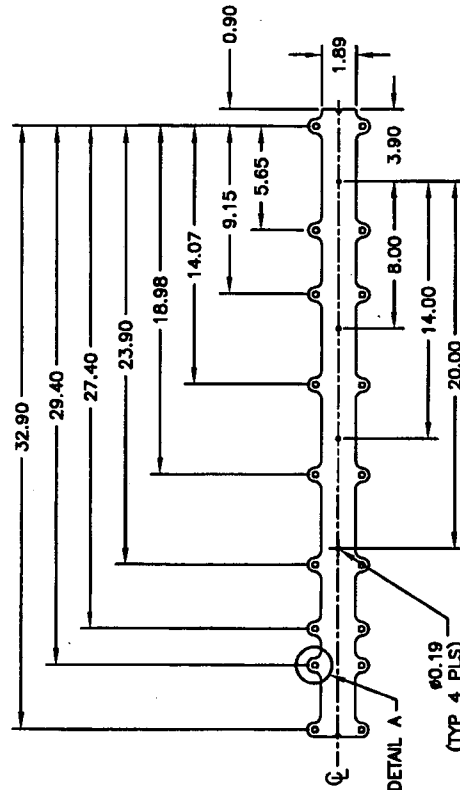
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| DESIGN CB | DRAWN BY CB | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | APPROVED | DRAWING NO. D3536 | REV. A SHEET 1 OF 6 |
| DATE 06.10.25 | TITLE GASKET | | SCALE 1:10 |
| A | 06.10.25 | NEW ISSUE | |

RELEASED

09.02.12

**D3536-11 GASKET****D3536-13 GASKET**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- SEE PAGE 6 FOR DETAILS AND SECTION

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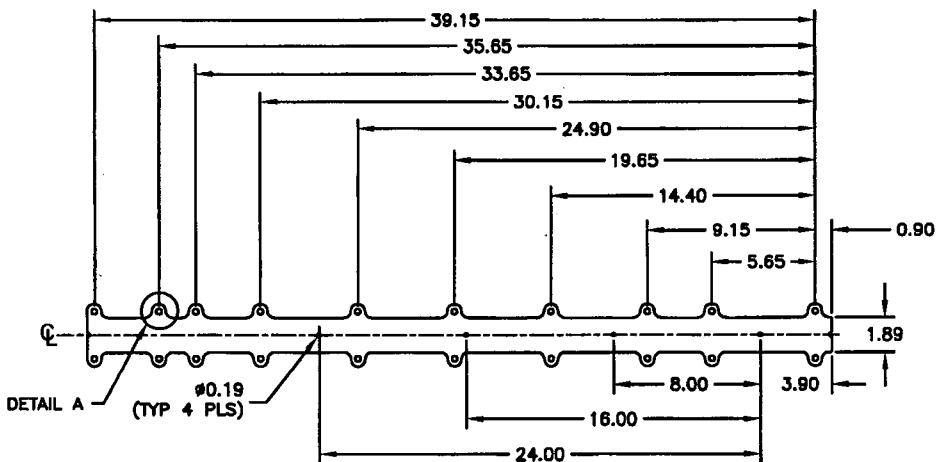
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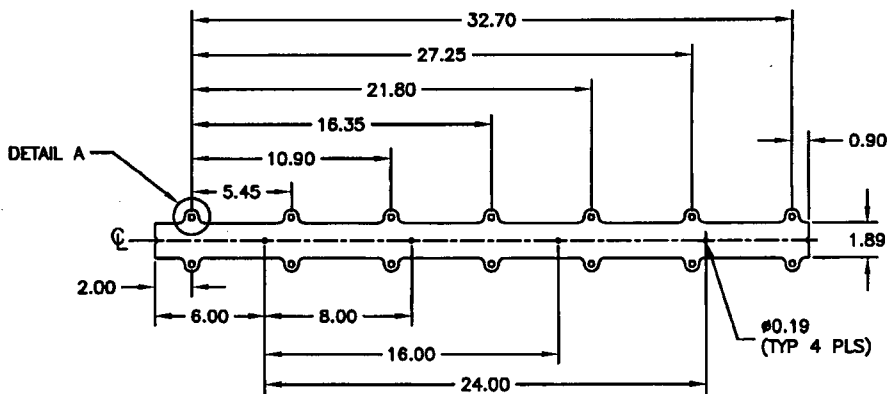
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| DATE | 06.10.25 | TITLE | GASKET | REV. A | SHEET 2 OF 6 |
| | | | | SCALE | 1:10 |

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07.02.12



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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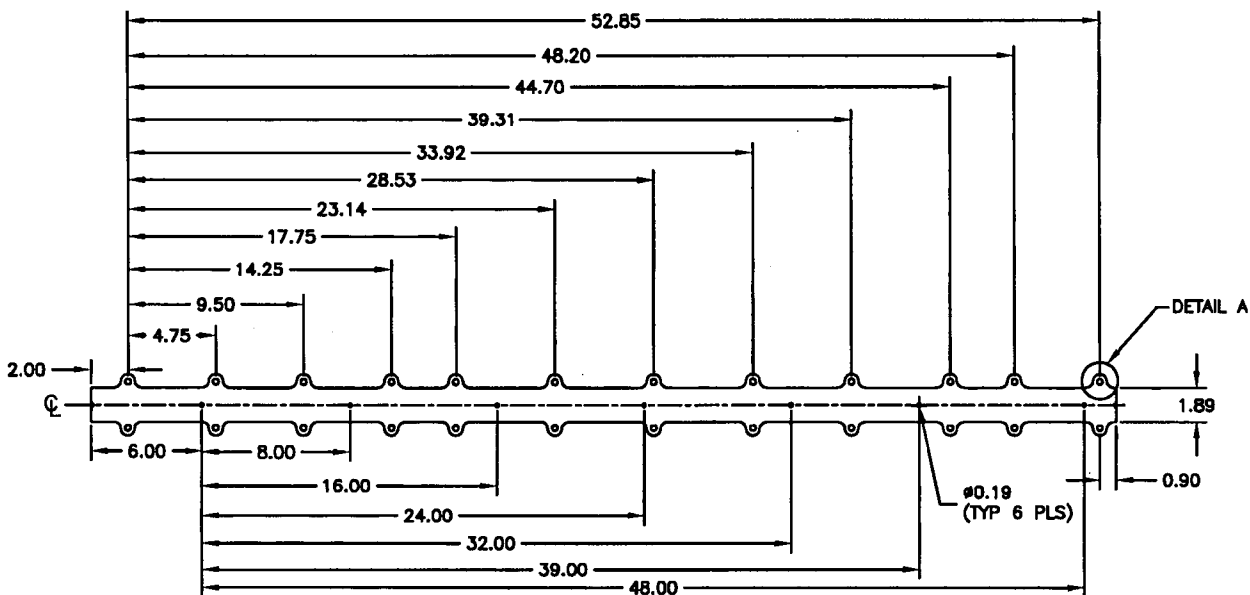
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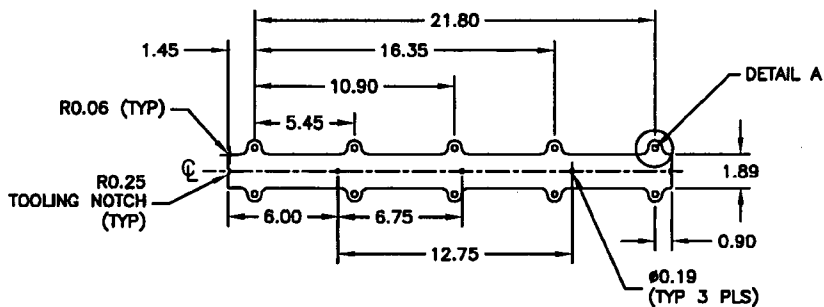
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| | | DRAWING NO. | D3536 | SHEET 3 OF 6 |
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D3536-23 GASKET



D3536-25 GASKET

NOTES

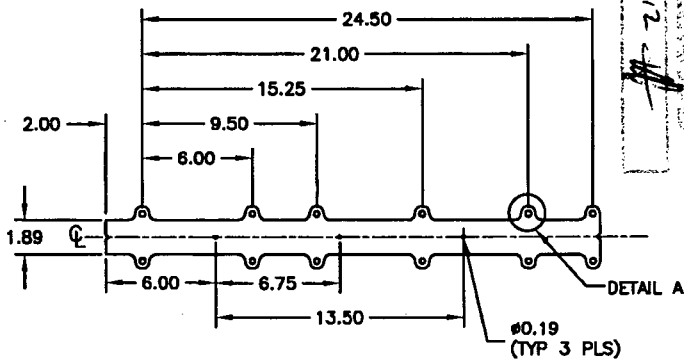
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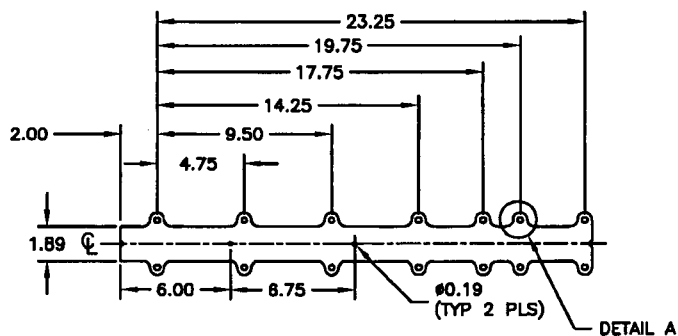
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| | | TITLE | GASKET | SHEET 4 OF 6 |
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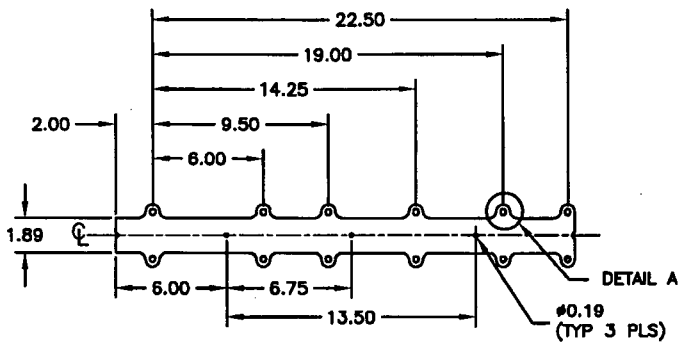
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

NOTES

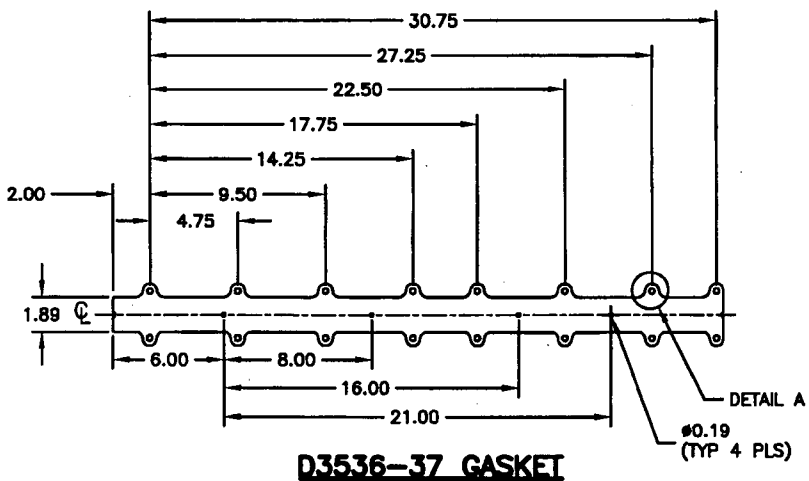
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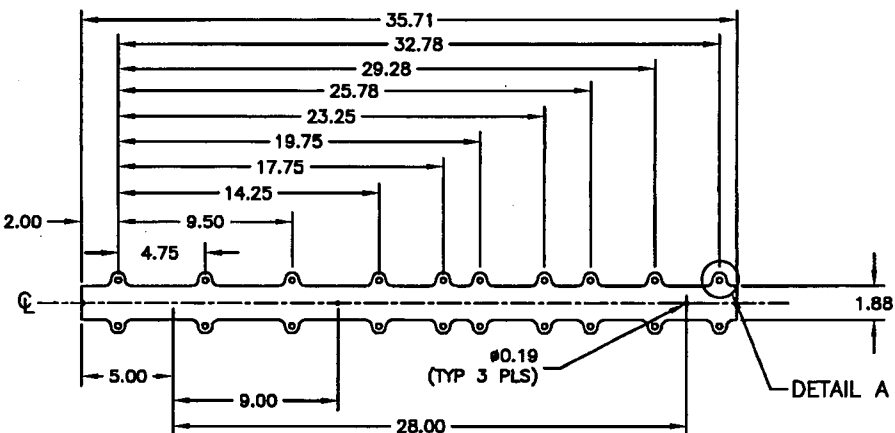
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| DATE | 06.10.25 | TITLE | D3536 | GASKET | SCALE |
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07.02.12 CH



D3536-37 GASKET



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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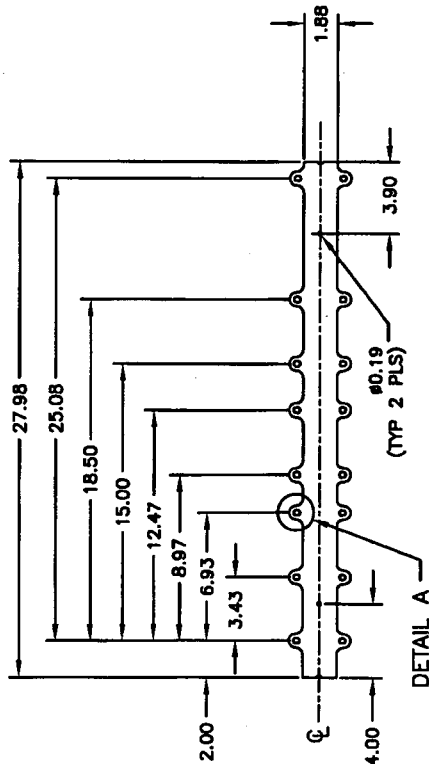
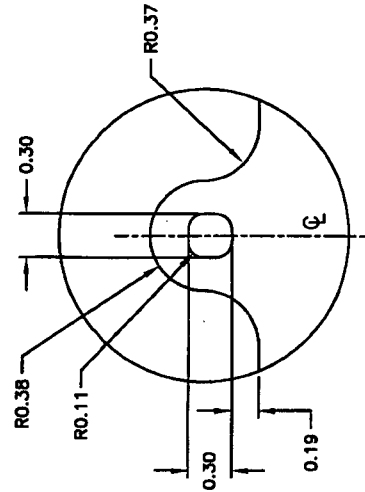
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| DATE 06.10.25 | | TITLE GASKET | SCALE 1:10 |

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DETAIL A



DETAIL A

D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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